

Date: Wednesday, 12/5/2007 8:00:14 AM
User: Kim Johnston

Process Sheet

SPLIT

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MOUNTING LUG
Job Number : 36102	
Estimate Number : 10255	
P.O. Number : <i>N/A</i>	Part Number : D22301
This Issue : 12/5/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2230 REV F
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i>	Drawing Revision : F
Previous Run : 33250	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 12/20/2007
Checked & Approved By : <i>[Signature]</i>	Qty: <i>100</i> Um: <i>200</i> Each
Comment : Est D 00.11.01 Added inspection level 8, and removed P/O for powder coat EC	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.0717 f(s)/Unit Total: 14.3430 f(s)
Lug Extrusion D2423 Extrusion
Batch: *B33310*

2.0 BAND SAW BAND SAW



Comment: BAND SAW
Cut D2423 extrusion to 0.82"
Batch: *B33310*

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1

PG



Issue PO 5204 Meter

CO 7/12/05



(200)

Comment: HAAS CNC VERTICAL MACHINING #1
1-Machine per folio D2230-1
(Check for crack while loading into the machine.)
2-Tumble and deburr rough edges after tumbling

Machine per drawing D2230 Rev F

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

RG



Review & inspect for transit damage



Comment: INSPECT PARTS AS THEY COME OFF MACHINE *Ensure C of C attached*

CO 8/1/04 (100)

5.0 QC5 SECOND CHECK



Comment: SECOND CHECK *Inspect Level 3*

5860607

co-centers (100)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 08/01/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/5/2007 8:00:14 AM
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Drawing Name: MOUNTING LUG

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Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



100X

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-L

08/01/07

7.0

QC5

INSPECT WORK TO CURRENT STEP



check

Comment: INSPECT WORK TO CURRENT STEP

08/01/07

100

8.0

POWDER COATING

POWDER COATING



100

Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

M 100 379

BL

08-01-07

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



100X

Comment: INSPECT POWDER COAT

M-L

08/01/07

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8/1/07 50

100X

11.0

QC21

FINAL INSPECTION/W/O RELEASE



100

Comment: FINAL INSPECTION/W/O RELEASE

08/01/07

Job Completion



U 08/01/07

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:

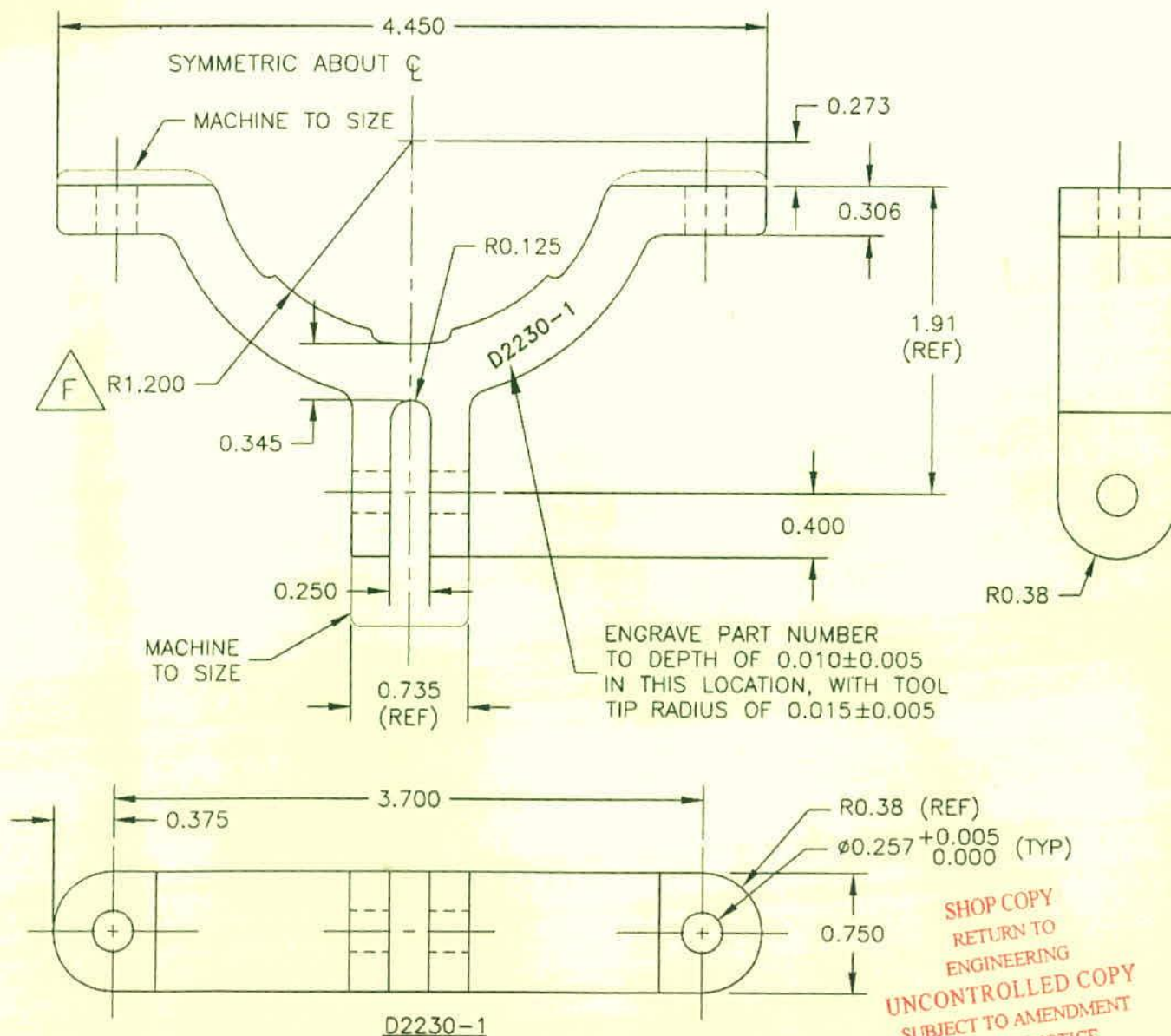
WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2230	REV. F SHEET 1 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1
C	94.03.30	RE-DESIGN	
D	95.01.04	RE-DESIGN	
E	95.01.04	RE-DESIGN	
F	99.12.13	REDESIGN; R1.200 WAS R1.100	

RELEASED
99-12-21 DS

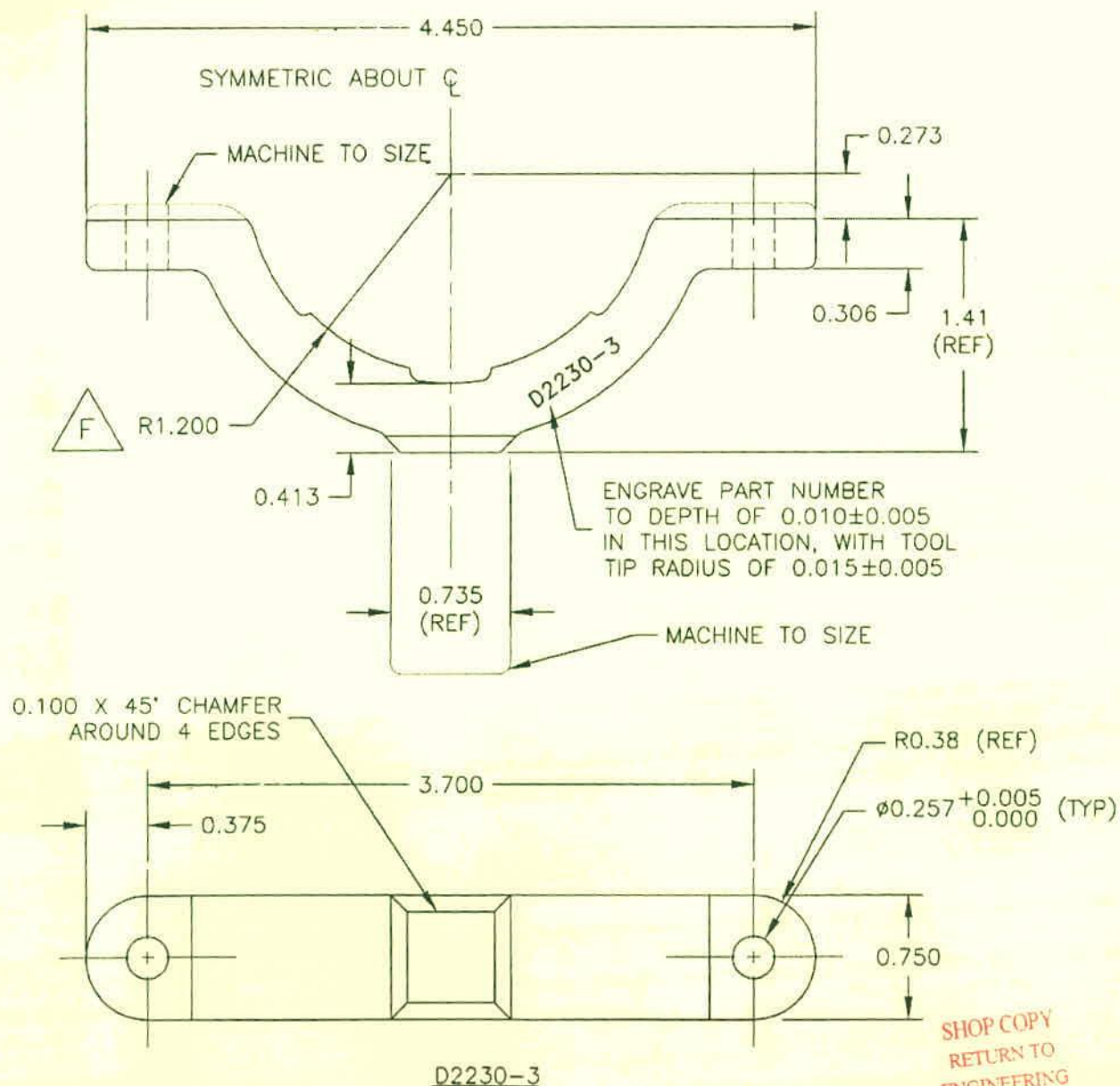
MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36102

THE
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OF THE
MUSEUM OF
COMPARATIVE ZOOLOGY
AT HARVARD UNIVERSITY
Cambridge, Mass.
1881

DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2230	REV. F SHEET 2 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
99.12.21 DS

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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NO. 36102



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

100

D2230-1

Lug B36102

5206

MATERIAL: supplied by DART D2423 B33310

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, January 2, 2008

